

To illustrate the use of this jig, suppose that a number of holes must be accurately located, drilled, and reamed in a die-block. After the block has been planed up perfectly square, parallels are clamped to the edges so that they overhang in the manner shown in Fig. 26, allowing the pins *B* to engage with these parallels when the jig is laid flat against the die-block. The bushing *C* is located at a known distance from the edges of the jig, and by setting the pins *R* in the required position by means of a micrometer or micrometer depth gage,



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Fig. 26. Method of using Universal Drill Jig shown in Fig. 25

the bushing is located in position for drilling the hole in the die-block. For this purpose, the jig* is clamped to the die-block with a pair of parallel clamps, after which the hole is spotted,

drilled
and reamed in the usual way. It will, of course, be evident that any number of holes that come within the range of the jig can be located on the die-block in the same way. The usefulness of this tool will be apparent to any toolmaker, and many uses will be found for it that, may not be seen at the first glance. A universal jig which is in the form of an attachment which is clamped to the table of a drilling machine is shown in Fig. 27. The drill bushing is in line with the axis of the machine spindle, so that holes may be drilled as in the case* of an ordinary jig, and there is a compound table with slides at right angles, which